

Work Order ID 70326

Thursday, June 02, 2011 2:54:17 PM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: W Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG0011

Sulesly

for BG 11-6-27
(10)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R: Aluminum Rod

3-Grind End Plate flush

M114703
M117884

A.E 11.06.26

11-06-20

(10)

B7D 326 left hand!

Work Order ID 70326

Thursday, June 02, 2011 2:54:17 PM

Page 2

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 6/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 8 11/06/21

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/21

410
LH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11.06.21

410

Work Order ID 70326

Thursday, June 02, 2011 2:54:17 PM



Page 3

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 6/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

SP 11/06/23



Memo

0.00

180



Large Fab

Large Fab

Large Fab

Memo

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R: Aluminum Rod 1114703

6-Grind End Plate flush

7-Install last rivet as per Dwg.

0.00

0.00

11.06.28

10



11.06

Work Order ID 70326

Thursday, June 02, 2011 2:54:17 PM

Page 4

Item ID: D350-591-311

Accept

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011 Start Qty: 10.00

Required Date: 6/10/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

S w/06/30

QC

Memo

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

0.00

S w/06/30

QC

Memo

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

HandFinish

Memo

Hand Finishing



10 LH. - BL 11-6-30.

Work Order ID 70326

Thursday, June 02, 2011 2:54:17 PM



Page 5

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 2:00

OVEN TEMPERATURE: 320

FINISH TIME: 2:30

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10.00 M-11/07/04

10.64 H 11/07/05

8/10/11

200
47

Work Order ID 70326

Thursday, June 02, 2011 2:54:17 PM

Page 6

Accept

Setup Start

Stop

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011 Start Qty: 10.00

Required Date: 6/10/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/11 S (100)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5 units

200
44

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: HA11

QEU B

11/7/11 S (100)

Work Order ID 70326



Page 7

Thursday, June 02, 2011 2:54:17 PM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling:

Date:

Stop



QC: Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11
mf
11-07-11

Picklist Print

Thursday, June 02, 2011 2:54:11 PM

Page 1

Work Order ID: 70326

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH



Start Date: 6/10/2011

Required Date: 6/10/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 104.03.22 New issue 11KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	10			
Step													
D3067-1 		Manufactured	No			110	Each	95.0000	1	10			
End Plate													

11.06.06 B70324 @

11.06.17

Location	Loc Qty	Loc Code
WA	2	
67582	2	
WA016	93	
68214	93	

10

D3219-1 		Manufactured	No			110	Each	144.0000	2	20			
Plate													

11.06.17

Location	Loc Qty	Loc Code
WA	24	
68202	24	
WA017	120	
68338	120	

20

Picklist Print

Thursday, June 02, 2011 2:54:11 PM

Work Order ID: 70326

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011

Required Date: 6/10/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1

Manufactured No

180

Each

109.0000

2

20



Spacer



11.06.29

Location

Loc Qty

Loc Code

WA

109

68337

28

69738

81

20

MS20600-AD4W4

Purchased

No

180

Each

2,128.000

16

160



Rivets



11.06.29

Location

Loc Qty

Loc Code

ST321

2123

116188

123

117364

1000

117601

200

117885

800

160

WA018

5

116712

5

D3065-041

Manufactured

No

180

Each

8.0000

1

10



Step Leg Assembly Hi



11.06.29

Location

Loc Qty

Loc Code

WA

8

66149

0

67503

8

4

WA 69740 x6

Picklist Print

Thursday, June 02, 2011 2:54:12 PM

Page 3

Work Order ID: 70326

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011

Required Date: 6/10/2011

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180

Each

95.0000

1

10



End Plate



11.06.29

Location

Loc Qty

Loc Code

WA

2

67582

2

WA016

93

68214

93

AN3-35A

Purchased

No

250

Each

181.0000

2



Bolt



10

20

Location

Loc Qty

Loc Code

ST353

181

117313

31

117441

50

117619

50

117794

50

D3235-1

Manufactured

No

250

Each

81.0000

2



Mounting Lug



20

Location

Loc Qty

Loc Code

ST471

81

68292

81

D3278-041

Manufactured

No

250

Each

78.0000

1



Support Assembly



20

10

11/3/11 SLT 10

Location

Loc Qty

Loc Code

ST471

78

68957

38

69741

40

10

Thursday, June 02, 2011 2:54:12 PM

Shop Packet Print

Page 3

Picklist Print

Thursday, June 02, 2011 2:54:12 PM

Work Order ID: 70326

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011

Required Date: 6/10/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 , NAS1149D0463J Purchased No

250

Each

0.0000

16

160

Washer

AN960JD516 NAS1149D0563J Purchased No

250

Each

0.0000

4

40

Washer

AN5-36A Purchased No

250

Each

151.0000

2

20

Bolt

Location

Loc Qty

Loc Code

ST341

151

117366

101

117794

50

Manufactured No

250

Each

121.0000

2

20

D2618

Bushing

Location

Loc Qty

Loc Code

ST019

121

68249

58

69880

63

Manufactured No

250

Each

98.0000

4

40

D2230-3

Lug

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

94

68246

94

Thursday, June 02, 2011 2:54:13 PM

Shop Packet Print

Picklist Print

Thursday, June 02, 2011 2:54:13 PM

Page 5

Work Order ID: 70326

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/10/2011

Required Date: 6/10/2011

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

167.2696 1.2 12



Abraison Strip



11/17/12

840

→ measure SW 12/14

Location

Loc Qty

Loc Code

ST403	166.6	
68076	166.6	
ST409	0.6696	
63735	0.6696	

✓

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

2,531.000 2



Nut



20

840

Location

Loc Qty

Loc Code

ST300	2531	
116391	11	
116540	56	
116549	764	
117441	800	
117601	400	
117885	500	

20

AN4-13A

Purchased No

250 Each

134.0000 8 80



Bolt



11/17/12 11/13/11

840

Location

Loc Qty

Loc Code

ST357	134	
117628	134	

Thursday, June 02, 2011 2:54:13 PM

Shop Packet Print

Page 5

Picklist Print

Thursday, June 02, 2011 2:54:13 PM

Work Order ID: 70326

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH



Start Date: 6/10/2011

Required Date: 6/10/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L5 Purchased No

250 Each

1,192.000 2 20



MISS594

SL

8-HU Nut

Location

Loc Qty

Loc Code

ST300

1192

116105

232

116548

260

117441

500

117591

100

117611

100

MS21042L4 Purchased No

250 Each

5,791.000 8 80



SL

8-HU Nut

Location

Loc Qty

Loc Code

ST300

5791

116823

491

117441

3000

117601

800

117885

1500

AN960JD10 NAS1149D0363J Purchased No

250 Each

0.0000 4 40



MISS594

11/7/11 SL (12)

8-HU Washer

DART

DESIGN <i>QD</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	• REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04 [Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

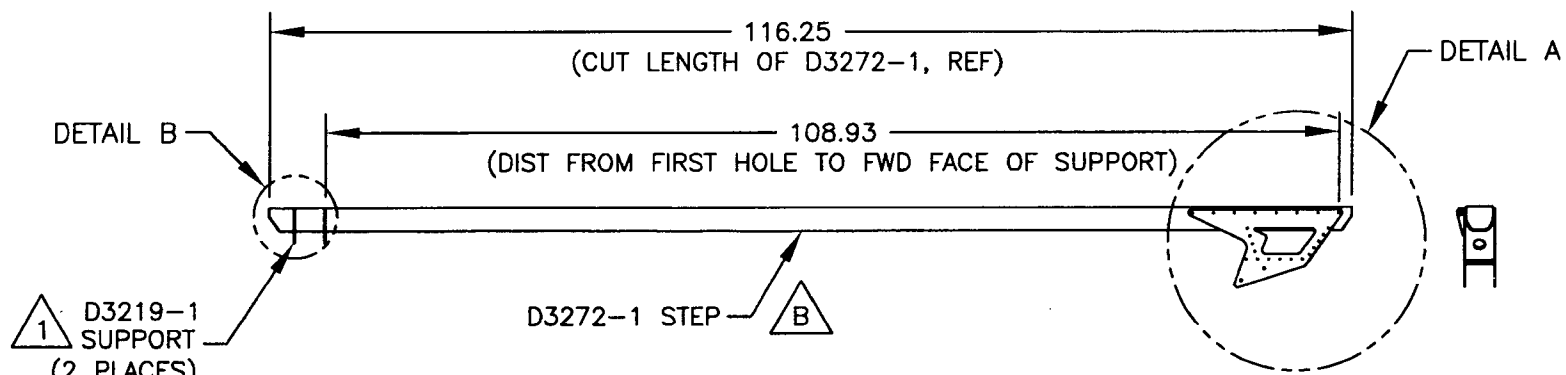
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*W/O 76326***Copyright © 2004 by DART AEROSPACE LTD**

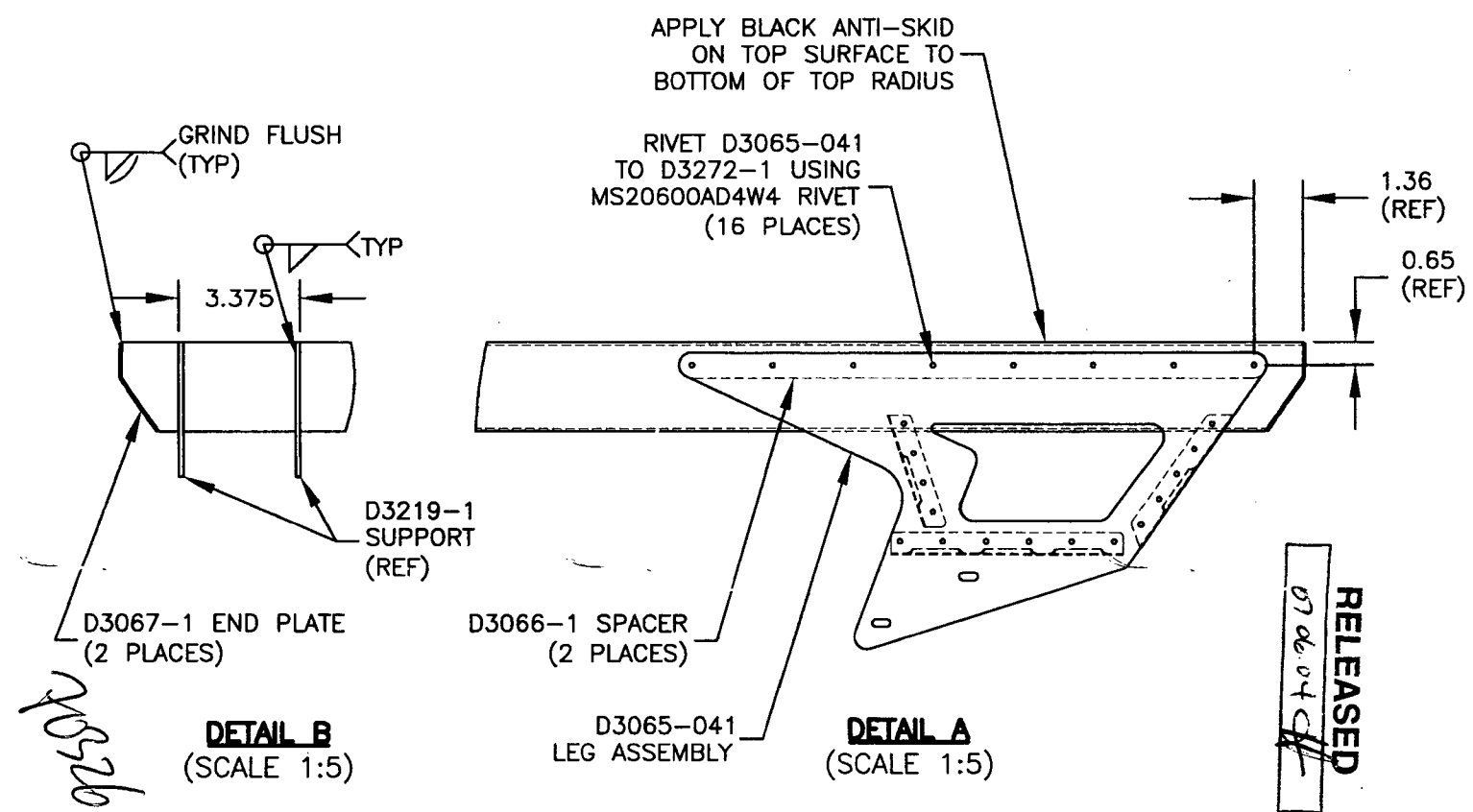
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	qo	DRAWN BY	ja	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CE	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		DRAWING NO.	D3272	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



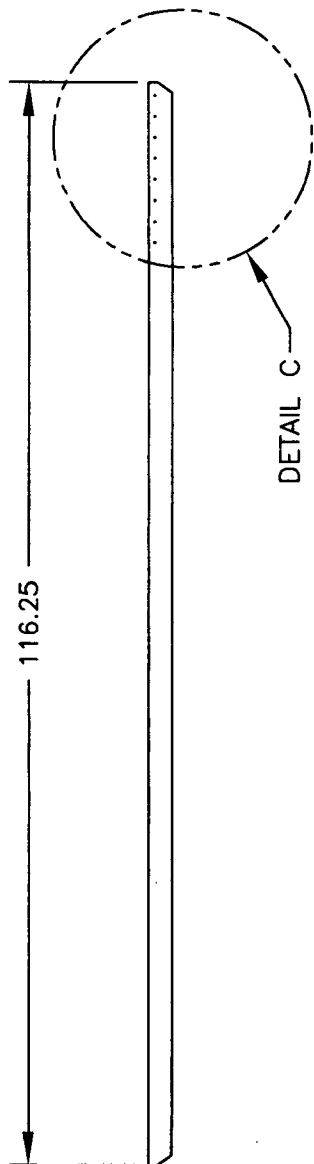
Copyright © 2004 by DART Aerospace Ltd
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

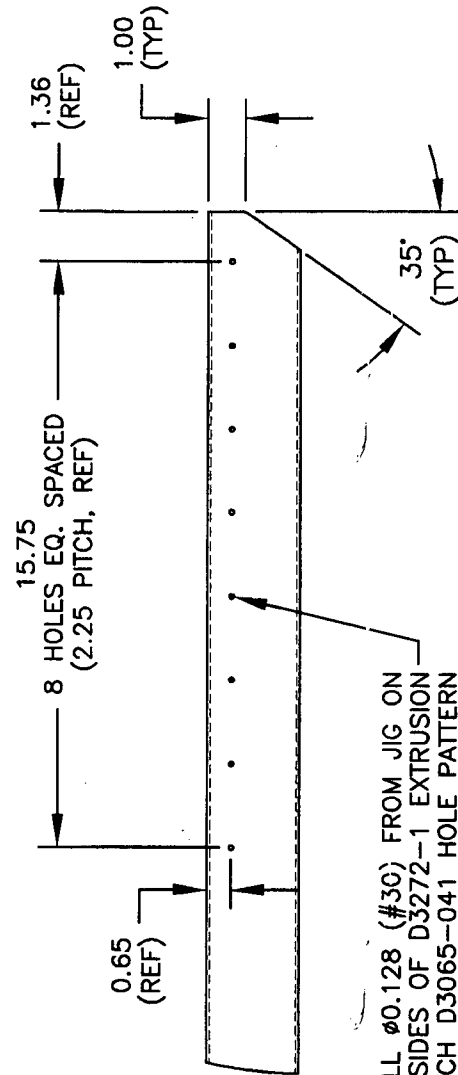
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



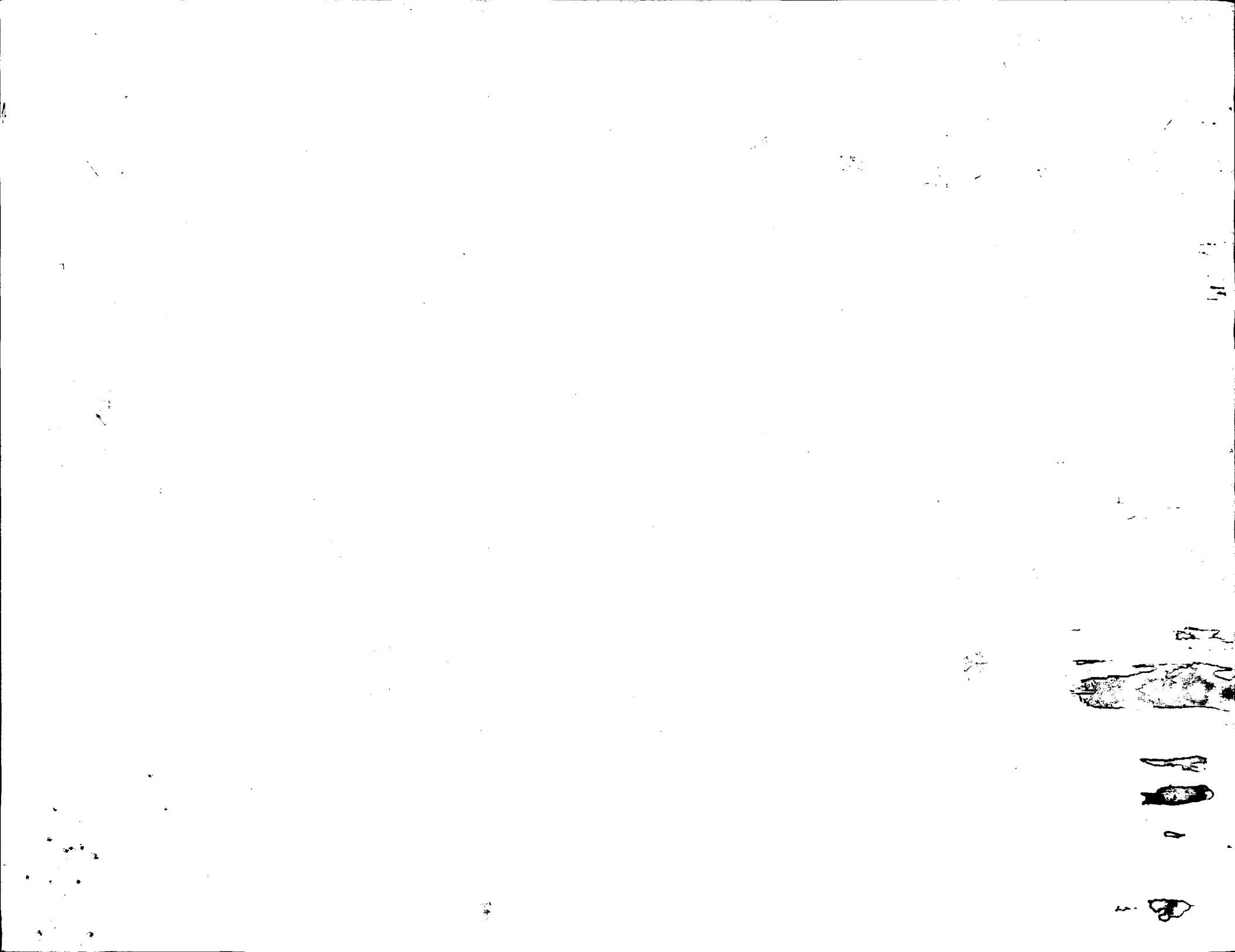
DETAIL C
(SCALE 1:5)

DRILL $\varnothing 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

20326

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.